

Date: Thursday, 02/04/2009 2:25:04 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	46828			Part Number	: D225223		
Estimate Number	13825			Drawing Number	: D2252 REV G		
P.O. Number				Project Number	: N/A		
This Issue	02/04/2009	S.O. No.	:	Drawing Revision	: G		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	14/04/2009	Qty:	1 Um: Each
Previous Run							
Written By							
Checked & Approved By	<u>JUD 09-04-02</u>						
Comment	Est Rev:A 09.03.18 New Issue EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
Comment: Qty.: 2.6775 f(s)/Unit Total : 2.6775 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M11148</u> <u>SAN 09-04-07</u>		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2252 2- Deburr and remove identification markings on tube <u>SAN 09-04-07 ①</u>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>6904-07 ①</u>		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Basket</u> <u>PD 09-04-07 ①</u>		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE <u>09/04/108 ①</u>		
Job Completion <u>10 09-04-07</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

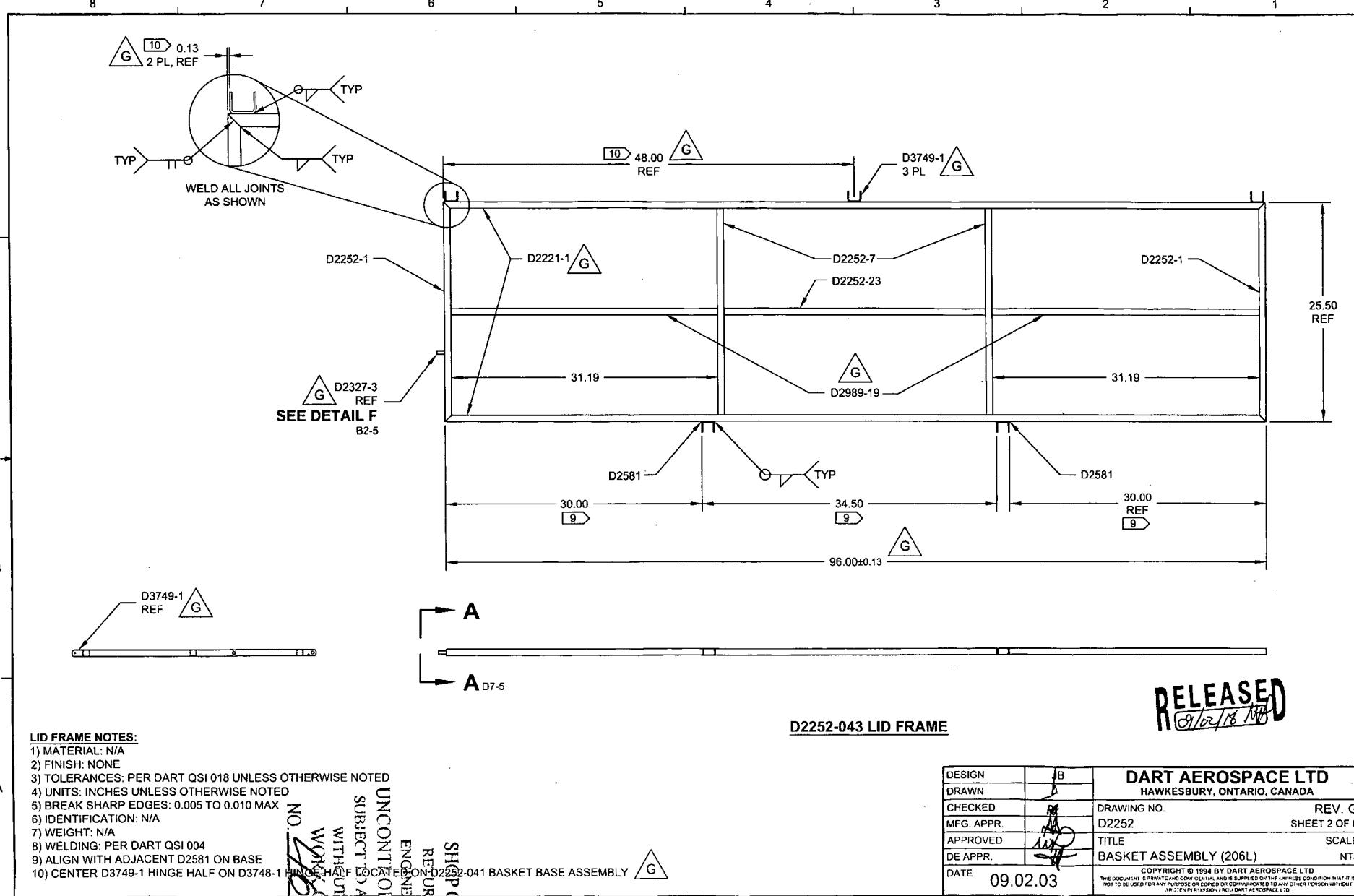
G G G

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01/04/18 PM

A	NOTES: 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING REF. DART SPEC M304TS0.750W.065 2) MESH MATERIAL: 3/4-16F EXPANDED SS REF DART SPEC M304EX0.75-16F 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 5) UNITS: INCHES UNLESS OTHERWISE NOTED 6) BREAK SHARP EDGES: N/A 7) IDENTIFICATION: N/A 8) WEIGHT: N/A 9) WELDING: PER DART QSI 004			B
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORKSOPPER Not for issue				
C	DRAWN BY: [Signature] CHECKED BY: [Signature] MFG. APPR.: [Signature] APPROVED BY: [Signature] DATE: 09.02.03			D
D	DRAFT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2252 REV. G SHEET 1 OF 6 TITLE: BASKET ASSEMBLY (206L) SCALE: NTS NOTES: THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.			E
E	DESIGNER: [Signature] DRAWN BY: [Signature] CHECKED BY: [Signature] MFG. APPR.: [Signature] APPROVED BY: [Signature] DATE: 09.02.03			F
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.			G
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.			H
H	MB 09.02.03			I
I	AJS 08.08.11			J
J	MB 05.11.10			K
K	BK 99.09.14			L
L	BK 95.12.11			M
M	BY DATE			N

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Not for issue



LID FRAME NOTES:

1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004
9) ALIGN WITH ADJACENT D2581 ON BASE
10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOC

NO. W001 SUBJECT: UNCON
WITH:

NO. 24252-041 BASKET BASE ASSEMBLY

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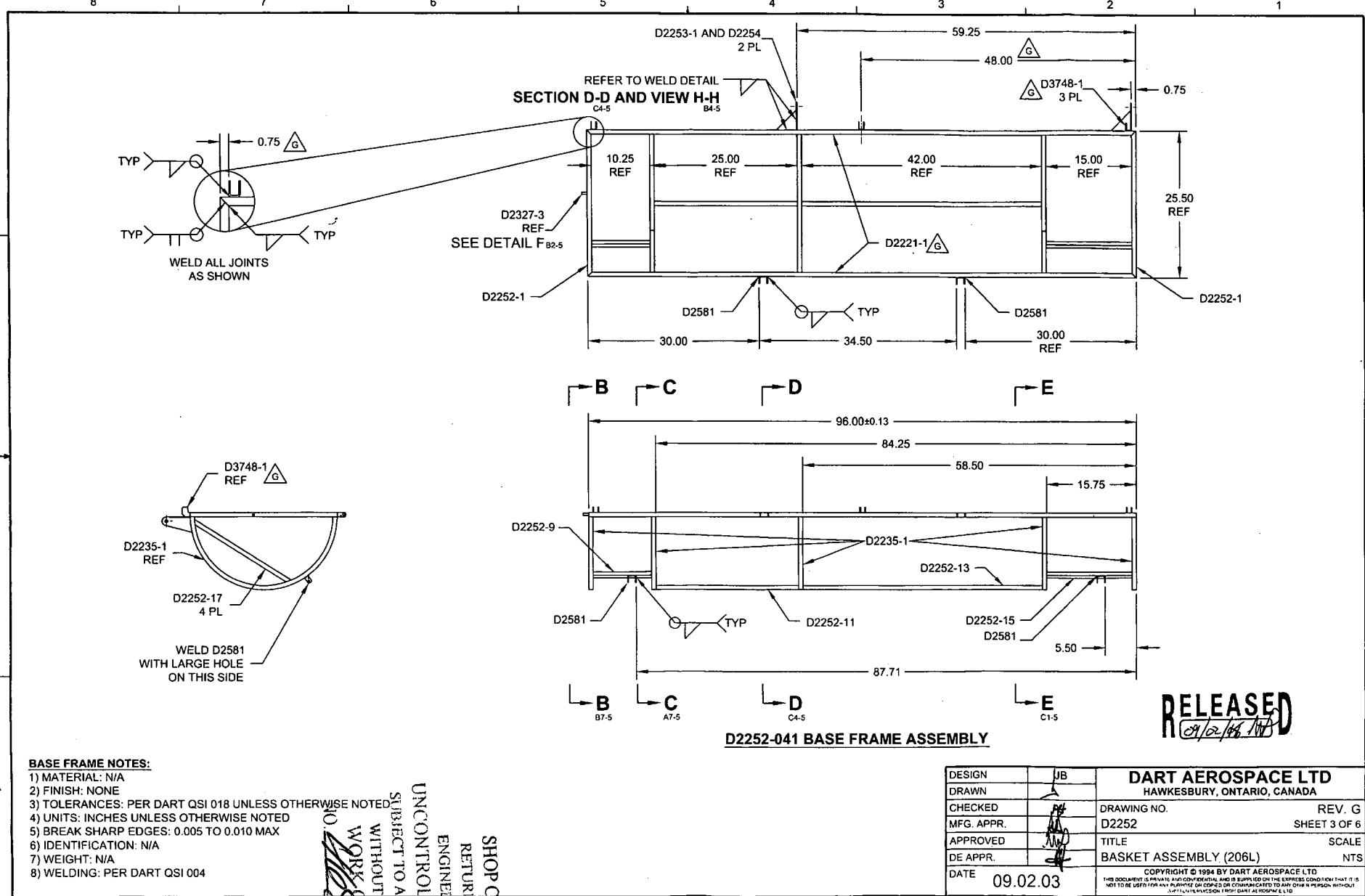
WORK ORDER

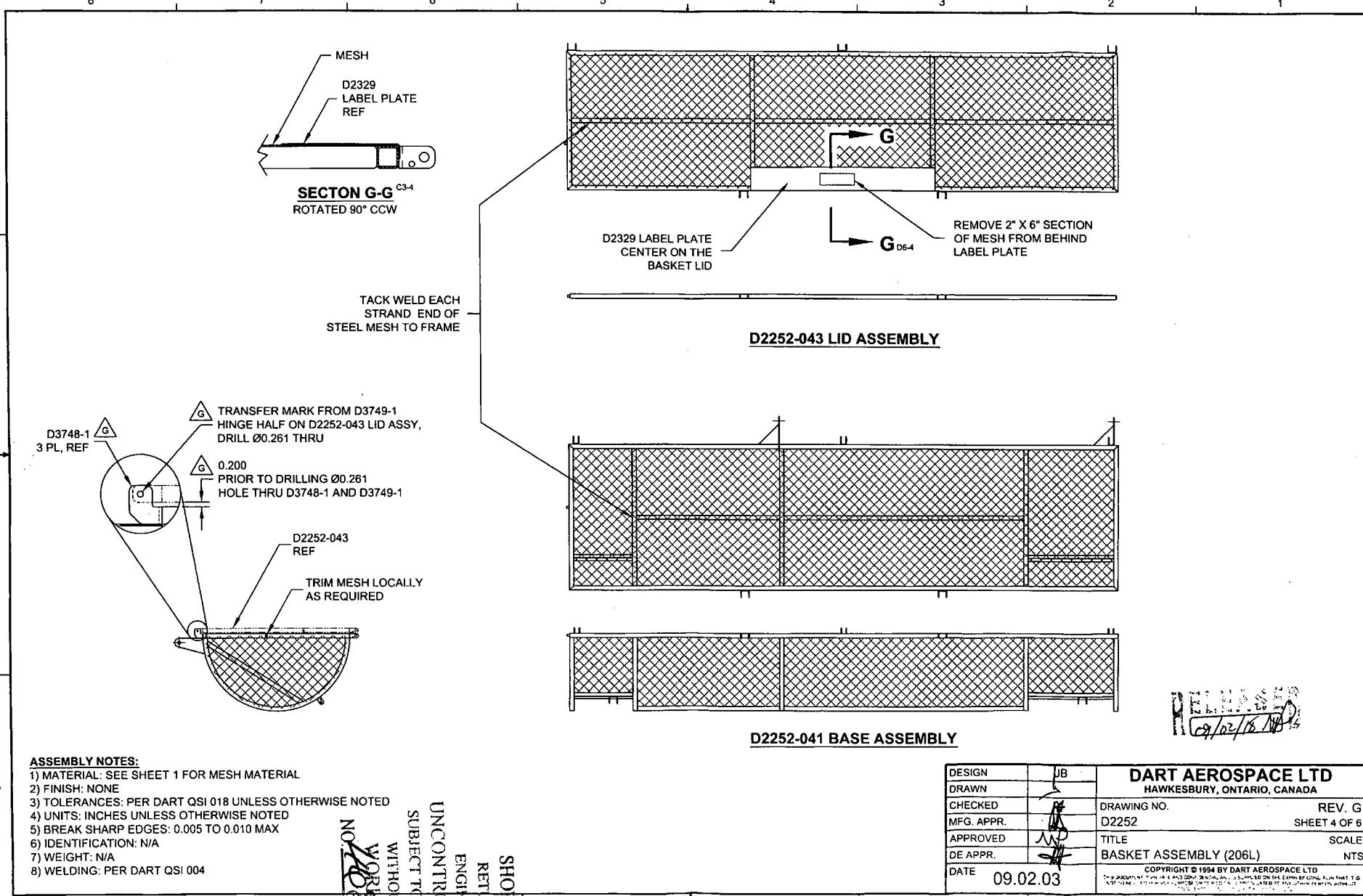
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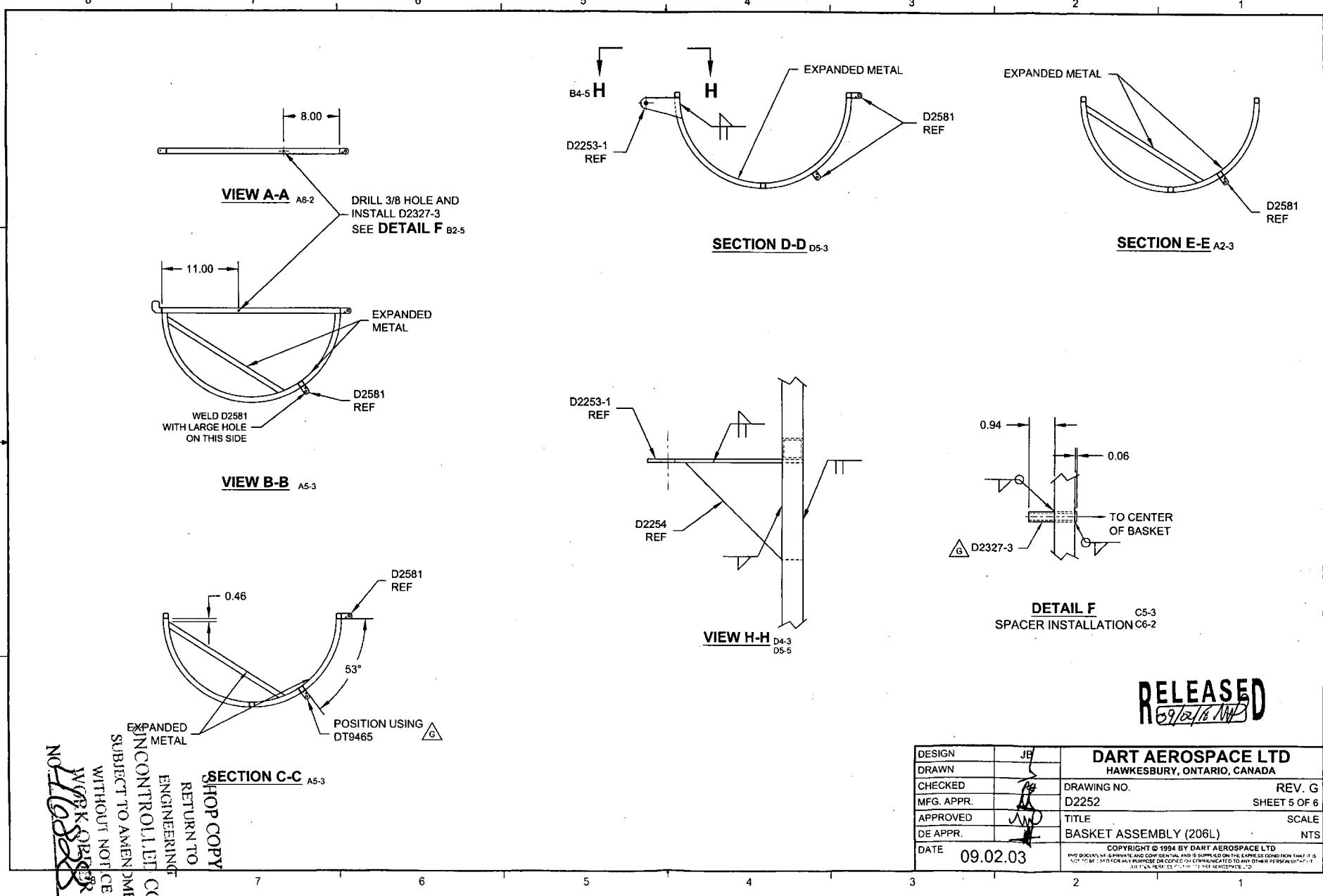
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D2252-043 LID FRAME

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CHECKED	<u> </u>	DRAWING NO.	REV. G
MFG. APPR.	<u> </u>	D2252	SHEET 2 OF 6
APPROVED	<u> </u>	TITLE	SCALE
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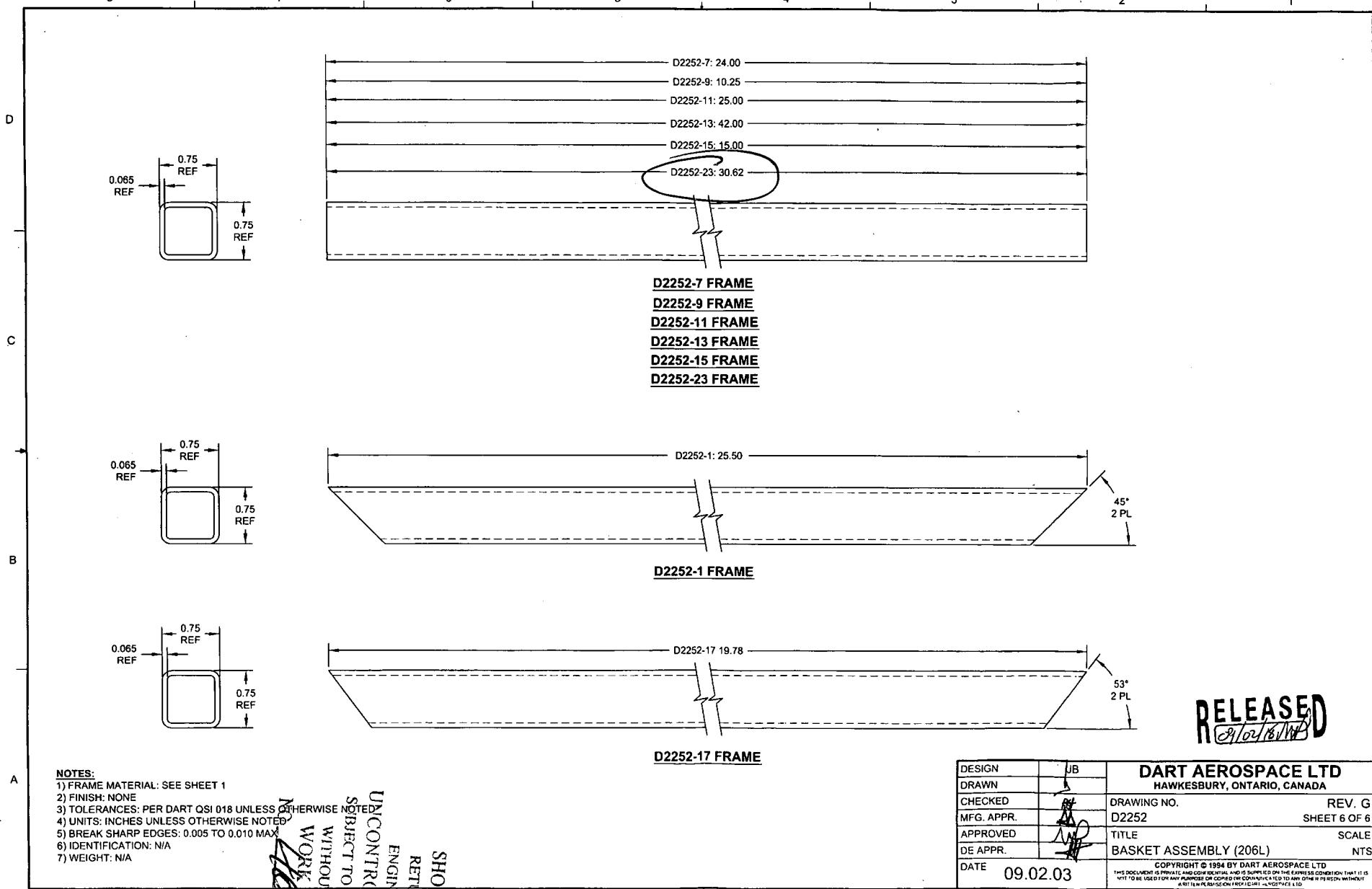


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